

Work Order ID 149906

August 10, 2016 10:57:24 AM

149906 RH

Page 1

Item ID: D205-634-145 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH
 Start Date: 8/8/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/29/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SA Date: AUG 08 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580-049	G
IIN-D205-634	REV H

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

110 Skidtubes 0.00
 110 Skidtubes
 Skidtubes Memo 0.06
 1- PICK D2580-1
 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021,
 DRILL 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF.
 ONLY)

DEC 06 2016

1 16-8-10

B149906 RH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 149906***149906***

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August 10, 2016 10:57:25 AM

Item ID: D205-634-145

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/29/2016

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.01

0.07

Memo

1-Bend as per program D2580.C on CNC Bender and Folio PT 16

2-Cut tubes as per Dwg. D2580

3- Scribe batch# in aft end of tube

0.00

0.36

Skidtubes

Memo

1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required.

2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7.

3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7.

4-Drill pilot holes for aft cap using DT8215, Open to finished size.

130

130

Skidtubes

Skidtubes

16-8-10 H.G.

16-8-10 H.G.

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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
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							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Item ID: D205-634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
18
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 8 16-08-10

150

Skidtubes

0.00

150

Skidtubes

Memo

0.17

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod
- Grind welds flush.

2-Touch up alodine on run on wearplate holes prior to swaging

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and as per dwg

4-DRILL TOWING HOLE USING DT8091

5-DEBURR

BE 16-08-10R.L. 16-08-1216-8-15 M.G.

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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149906

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Item ID: D205-634-145 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 8/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				1			DAS 38 9-89 AUG 17 2016
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 AUG 17 2016
180 *180* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo And realodine tube as per QSI 005	0.00 0.10				U			2016/08/17 BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐									

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[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID 149906

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149906

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Item ID: D205-634-145 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH
Start Date: 8/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* HandFinish Hand Finishing	Assemble as per dwg HandFinishing Memo 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 <u>M1135376</u> Sikaflex expire date: <u>16109</u> 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# <u>M136137</u>	0.00 0.15							134 f 22 16109/07
220 *220* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00							1

DAS
38
9-88
SEP 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 149906

149906

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1 *D2580-1* 205 Bent Tube		Manufactured	No				Each	4.0000	**	1			
Location Loc Qty Loc Code													
LG002 4													
148589 4													
D4202-1 *D4202-1* Spacer		Manufactured	No				Each	301.0000	**	24			
Location Loc Qty Loc Code													
LG001 301													
145902 5													
147952 296													
D2594-1 *D2594-1* Plug		Manufactured	No				Each	345.0000	**	8			
Location Loc Qty Loc Code													
FP001 345													
119830 68													
134804 16													
146645 201													
147564 1													
147974 27													
42807 25													
88922 7													

16-8-10 JH

1

24

16-08-12 R.L

24

8

all indicate

x 2

Picklist Print

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Page 2

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149906

Parent Item: D205-634-145

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Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 1.00

Required Qty: 1.00

D2576-3

Manufactured No

Each

50.0000

1

D2576-3

Step (Machining Detail)

8/16-08-10

Location

Loc Qty

Loc Code

LG001

50

136730

1

144673

12

148337

37

Each

726.0000

8

D2594-3

Manufactured No

D2594-3

O-Ring

all 16/08/07

Location

Loc Qty

Loc Code

FP001

726

135859

24

138060

2

140770

2

141703

12

145268

500

147875

186

Each

11.0000

1

D2855

Manufactured No

D2855

Cap

all 16/08/07

Location

Loc Qty

Loc Code

FP001

11

137568

11

Picklist Print

August 10, 2016 10:57:31 AM

Page 3

Work Order ID: 149906

149906

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

Each

389.0000

2

AN3-5A

**

Bolt

Location

Loc Qty

Loc Code

FP001

157

m133686

2

m134502

155

ST350

232

m135058

232

x2

NAS1149D0332J

Purchased

No

Each

1,368.000

2

NAS1149D0332.J

**

Washer

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

536

m134848

536

GA

467

m135046

467

x2

ST264

359

m135046

359

D5061-1

Manufactured

No

Each

1.0000

1

D5061-1

**

Fwd Wearplate

Location

Loc Qty

Loc Code

FP002

1

143869

1

x1

August 10, 2016 10:57:31 AM

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Page 3

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Page 4

Work Order ID: 149906

149906

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 1.00

Required Qty: 1.00

D5061-3

Manufactured No

Each

1.0000

1

D5061-3

Aft Wearplate

**

all 16/09/07

Location

Loc Qty

Loc Code

FP002

1

143870

1

1

AN4-45A

Purchased No

Each

52.0000

8

AN4-45A

BOLT

**

all 16/09/07

Location

Loc Qty

Loc Code

FP001

52

m134509

22

16

m135127

30

12

D2570

Manufactured No

Each

388.0000

16

D2570

Bushing

**

all 16/09/07

Location

Loc Qty

Loc Code

FG

12

88781

12

FP001

43

147395

43

16

ST008

98

145728

20

148886

78

ST012a

235

148174

235

Picklist Print

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Page 5

Work Order ID: 149906

149906

Parent Item: D205-634-145

D205-634-145

Parent Item Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Start Date: 8/8/2016

Required Date: 8/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042-4

MS21042L4

Purchased

No

Each

2.0000

8

MS21042-4

ll 16/09/07

Nut / use MS21042L4

Location

Loc Qty

Loc Code

ST304

2

9063

2

M133363

x 8

LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER
1	X				D2580-041
2		X			D2580-045
3			X		D2580-047
4				X	D2580-049
20	1	1	1	1	D2500-1-190
21			16	16	D2570
22	1	1	1	1	D2576-3
23		4			D2579
24	16	16	8	8	D2594-1
25	16	16	8	8	D2594-3
26	1	1	1	1	D2596
27	1	1	1	1	D2855
28	1	1			D3564-5
29	1	1			D3564-9
30	1	1			D3564-11
31	1	1			D3564-13
32	2	2			D3566-1
33	1	1			D3566-5
34	1	1			D3566-13
35	20	20	24	24	D4202-1
36			1		D4406-041
37			1		D4406-043
37				1	D5061-1
37				1	D5061-3
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130
51	50	50			AN3C4A
52	2	2	2	2	AN3-5A
53			8	8	AN4-45A
54	50	50			NAS1149C0332R
55	2	2	2	2	NAS1149D0332J
56			8	8	MS21042-4

GENERAL NOTES:

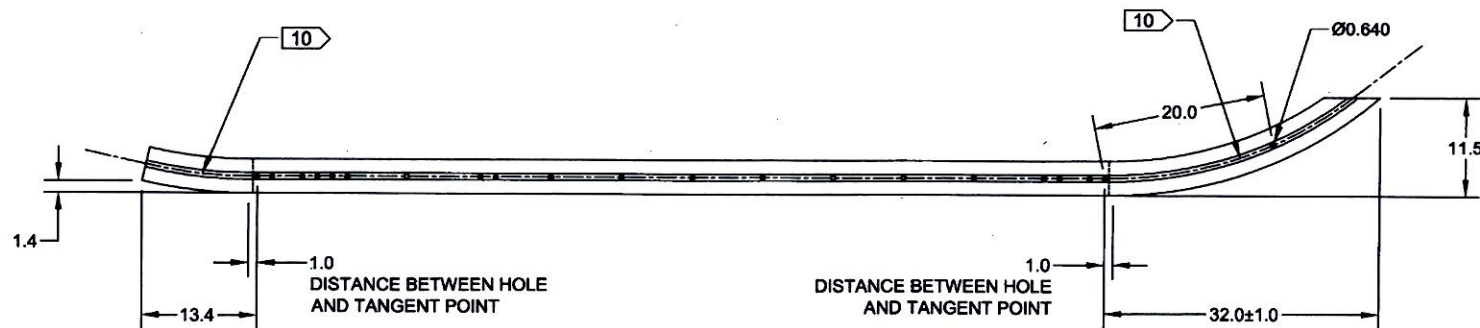
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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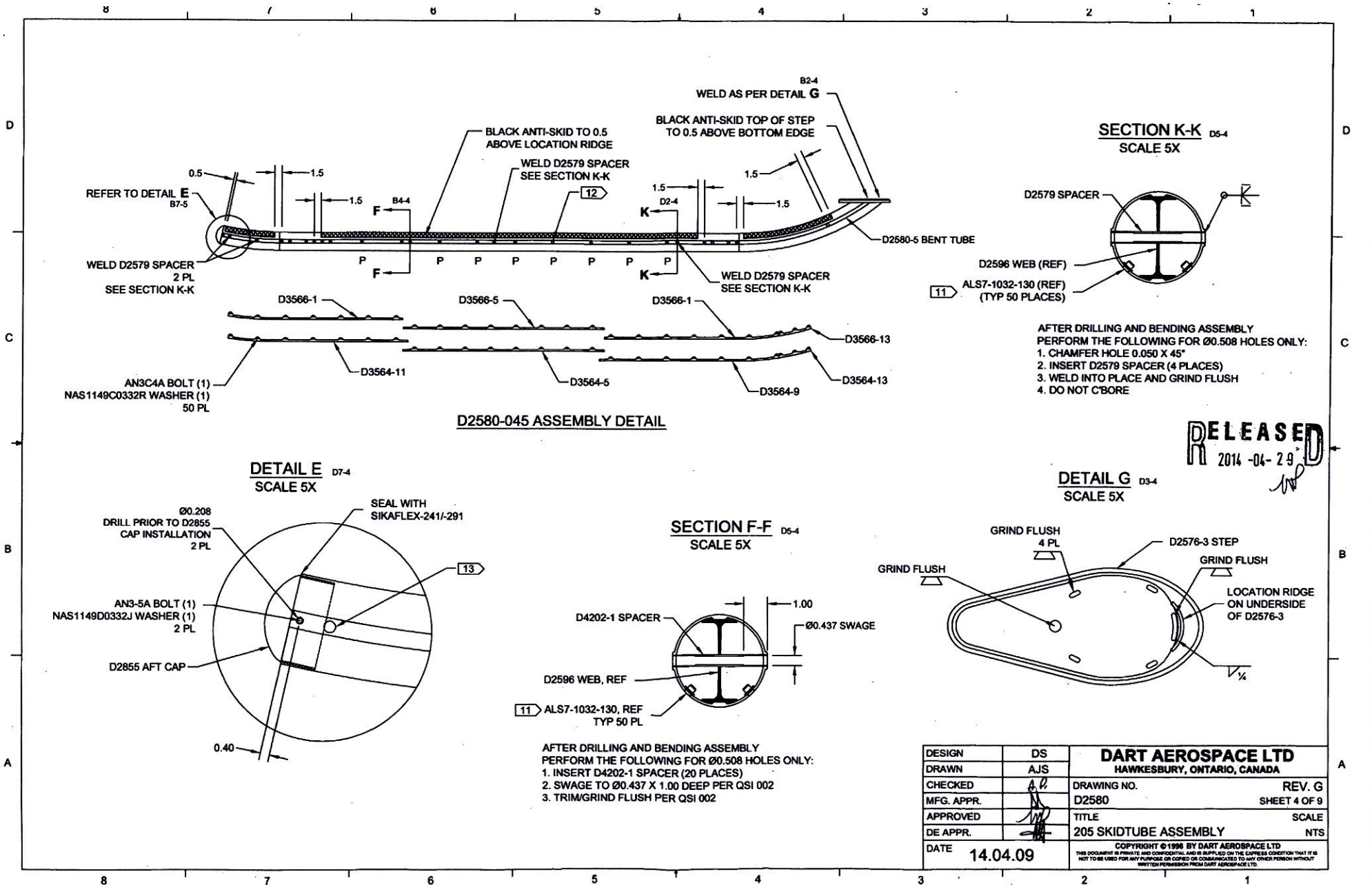
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9596	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	DS	D2580	SHEET 1 OF 9
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	205 SKIDTUBE ASSEMBLY	NTS
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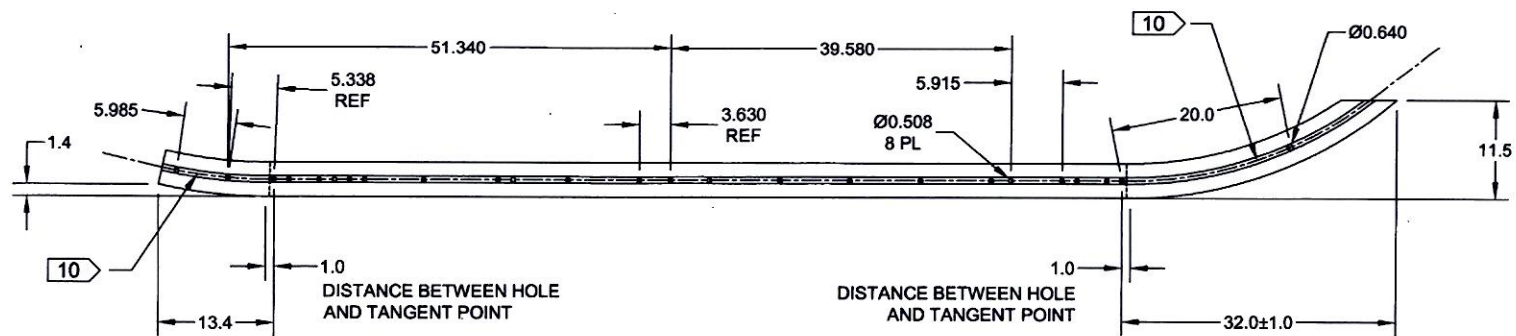


D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2014-04-29

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CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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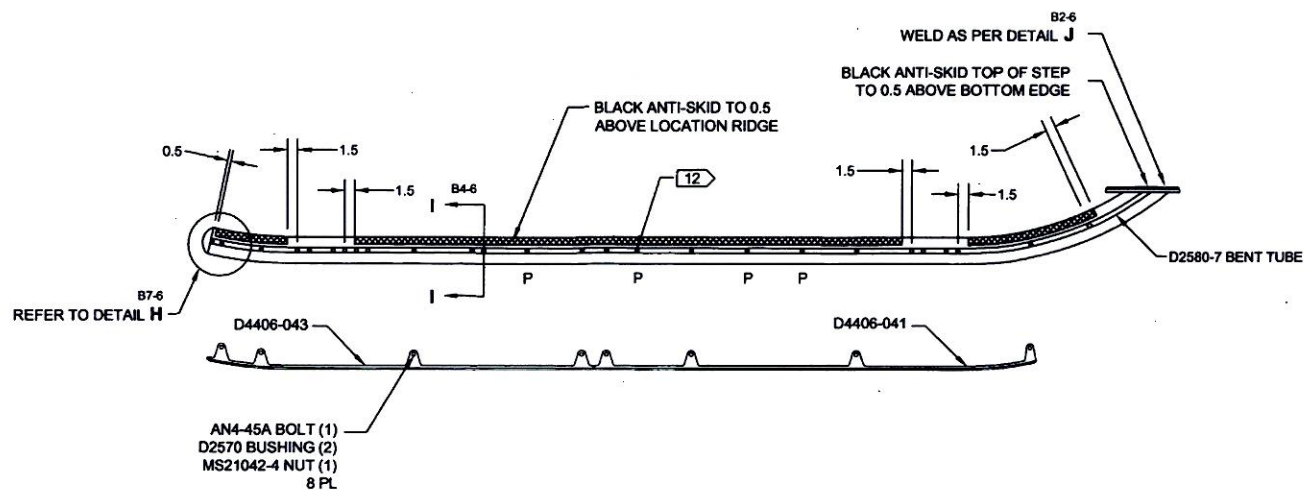




D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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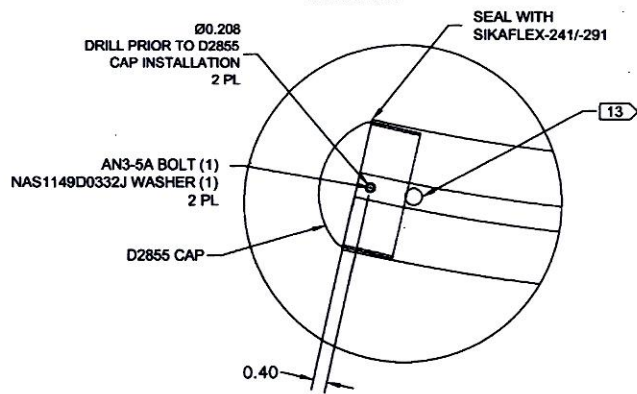
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2580	SHEET 5 OF 9
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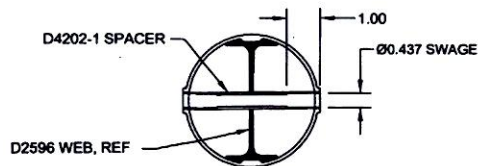
D2580-047 ASSEMBLY DETAIL

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DETAIL H
SCALE 5X

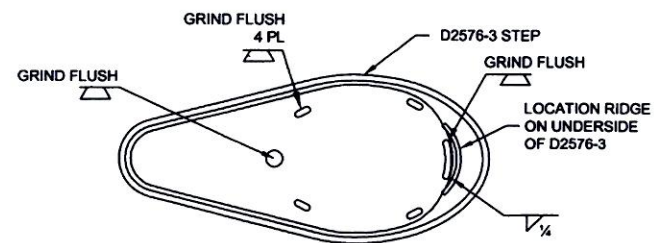


SECTION I-I
SCALE 5X

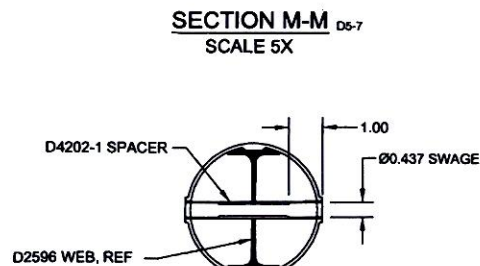
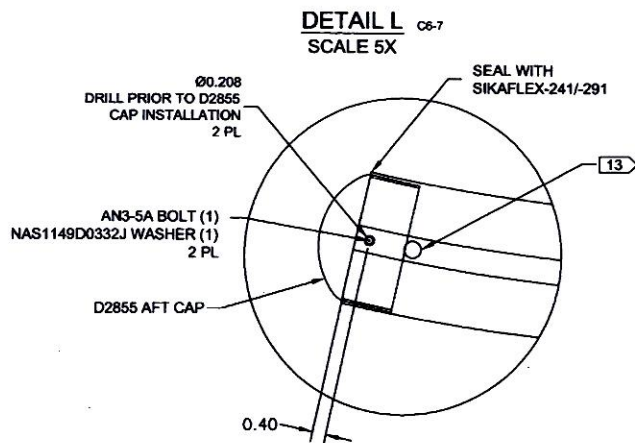
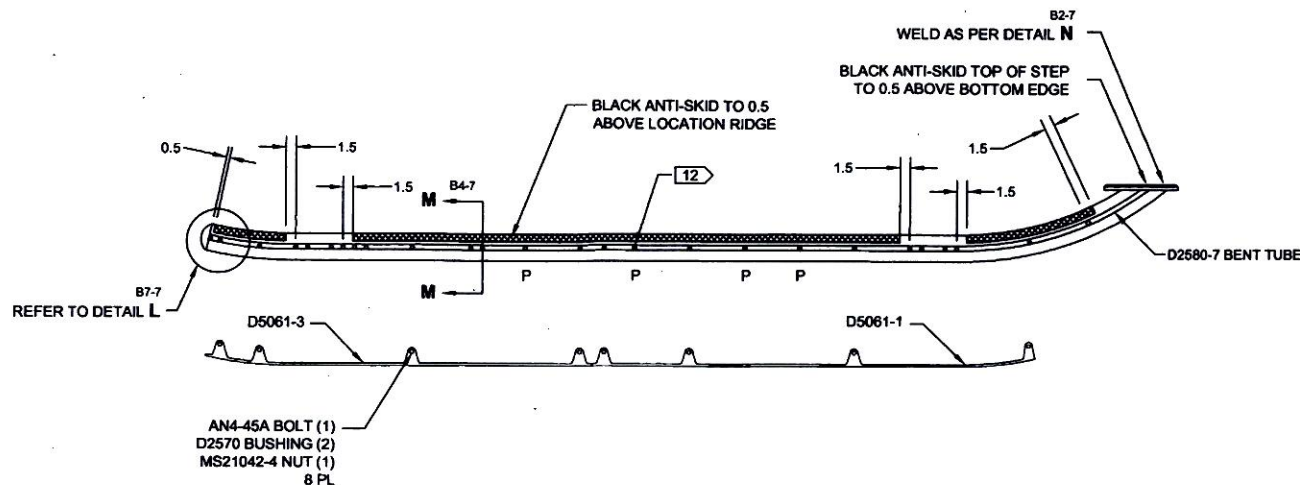


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

DETAIL J
SCALE 5X

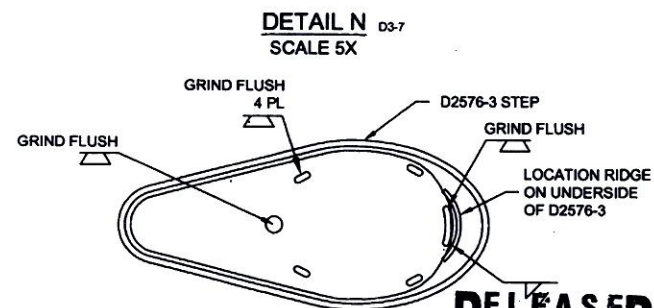


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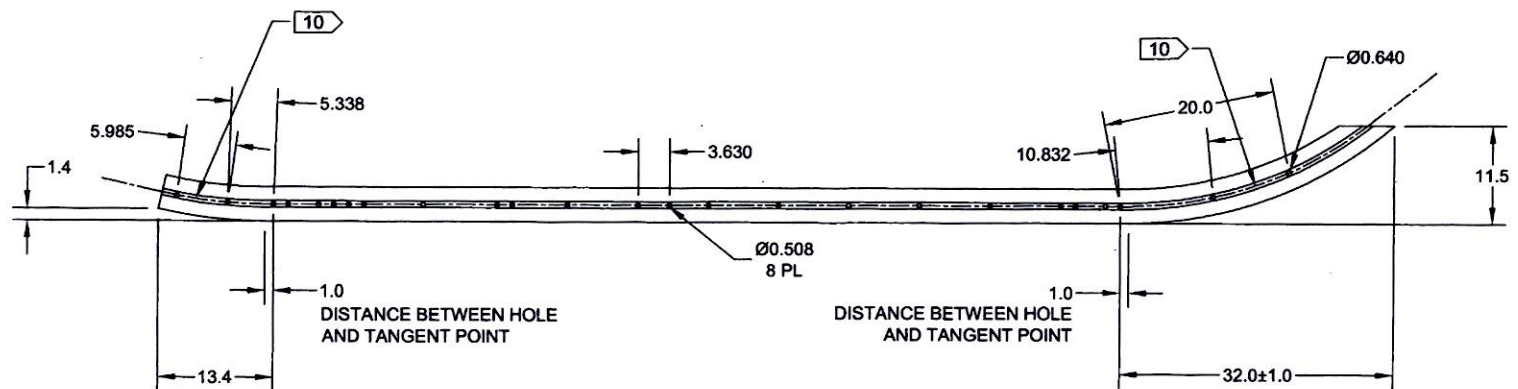
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



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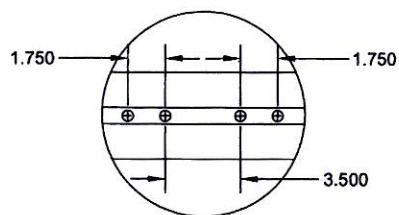
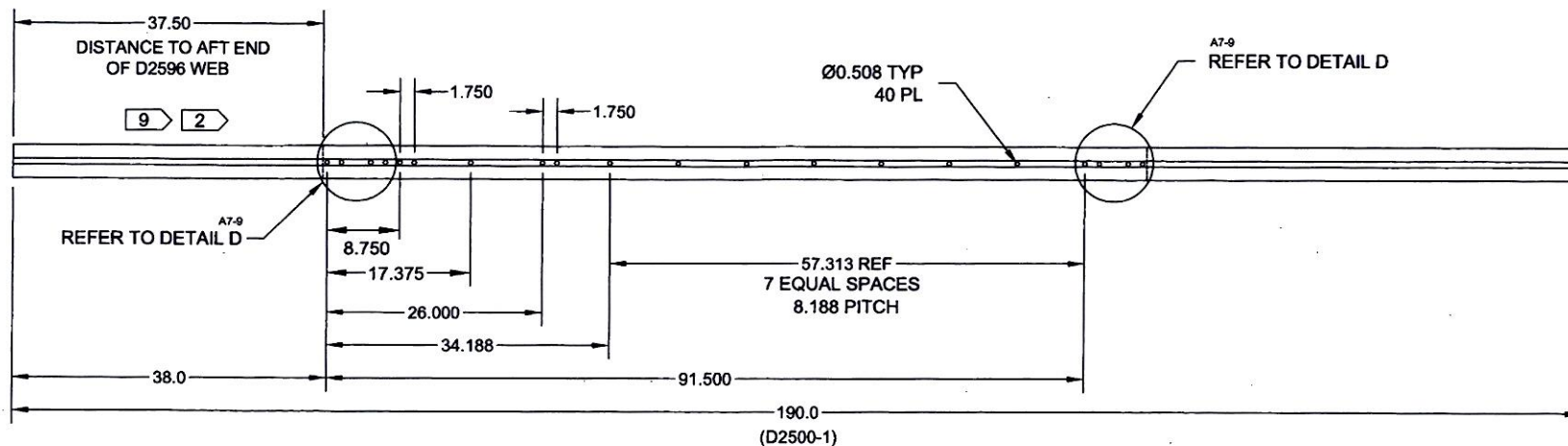
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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DETAIL D
SCALE 5X
C3-9
C7-9

D2580-101 TUBE

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DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	MA	D2580	SHEET 9 OF 9
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